



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200
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D3564-11
Job Sheet 192976



Part No: D3564-11

Job Qty: 10 pcs

Part Name: Wearplate Aft



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/5/19

Job Tracking No:

Due Date: 5/3/19

Created By: Marie Lajeunesse

Type: ~~Stock~~ *Sold*

Description:

Note: DWG REV E IPP Rev:A New Issue 07-03-08 ec IPP Rev:B As per Rev C 07-07-09 JLM IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC IPP Rev:D Comments revised on Step 5, 6 per B44656 09-02-06 KJ Verified By:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
100	Waterjet - Flow - 1	10 pcs	5/3/19	5/3/19	0.00	1.74	Waterjet - Flow			OK 19/04/29
120	QC 8	10 pcs	5/3/19	5/3/19	0.00	0.00	QC 8 - 12			
							QC 8 - 14			
							QC 8 - 17			
							QC 8 - 20			
							QC 8 - 25			
							QC 8 - 3			
							QC 8 - 32			
							QC 8 - 33			
							QC 8 - 35			
							QC 8 - 39			
							QC 8 - 4			
							QC 8 - 44			
							QC 8 - 45			
							QC 8 - 49			
							QC 8 - 58			
							QC 8 - 8			
							QC 8 - 9			
							QC 8 - 68			
							QC 8 - 67			
							QC 8 - 1 (A)			
							QC 8 - 47			
							QC 8 - 40			
							QC 8 - 52			
							QC 8 - 23			
					0.67		Small Fab - Brake - 1 - B4B			
							Small Fab - Brake - 2 - B4B			
							Small Fab - Brake - 3 - B4B			
140	QC 5	10	5/3/19	5/3/19	0.00	0.00	QC 5 - 10			

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Container No: S177009



Part: D3564-11

Job No: 192976

Serial No/Batch: S177009

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 05/13/19

DAS
40
MAY 06 2019
9-89
MAY 13 2019

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pcs					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	MAY 13 2019 DAS 68
					QC 5 - 9	9-89
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
150	Automated Welding - B4B	10 pcs	5/3/19	0.00 4.25	Automated Welding - 1 - B4B	<i>ML</i>
160	QC 10	10 pcs	5/3/19	0.00 0.00	QC 10 - 10	
					QC 10 - 18	
					QC 10 - 24	
					QC 10 - 43	
					QC 10 - 50	<i>EL</i>
					QC 10 - 58	
					QC 10 - 9	
170	QC 5	10 pcs	5/3/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	<i>EL</i>
					QC 5 - 30	
					QC 5 - 40	
180	Spray Paint - 2 - B4B	10 pcs	5/3/19	0.00 1.00	Spray Paint - 1 - B4B	<i>-RD 19-5-13</i>
					Spray Paint - 2 - B4B	
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
190	QC 5	10 pcs	5/3/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	

200	Packaging 3-1 - Stock - B4B	10 pcs	5/3/19	0.00 0.00	QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	DAS
					QC 5 - 40	MAY 14 2019 40
					Packaging 3 - 1 - B4B	9-89
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	fp.002 14-5-10
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
210	QC 21 - SA	10 pcs	5/3/19	0.00 0.00	QC 21 - SA - 21	MAY 14 2019
					QC 21 - SA - 70	21 MAY 14 2019
					QC 21 - SA - 53	53 MAY 14 2019

Part Op 100 - 1-Cut D3564-1 as per Dwg D3564 Dwg Rev: E Prog Rev: E 2-Deburr if necessary
 Descriptions: 120 - (QC8- Inspect parts - second check)
 130 - Form on Brake as per Dwg D3564 using Jigs DT8179
 140 - (QC5- Inspect part completeness to step on W/O)
 150 - (Automated welding) 1- AUTOWELD AS PER DWG AND QSI004 8259 HARDCOAT BATCH: _____
 160 - (QC10- Inspect visual per QSI004- ground welds)
 170 - (QC5- Inspect part completeness to step on W/O)
 180 - (Spray Paint / NDT Room) APPLY COATING ON CONCAVE SURFACE AS PER DWG AND QSI005 (SEE NOTE 12 ON DWG) 5150450 5106783 (4 units)
 190 - (QC5- Inspect part completeness to step on W/O)
 200 - (Identify as per dwg & Stock Location: _____)
 210 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	14.1000 sf (1.41 ea)	100-Waterjet - Flow - 1	<u>5152146</u>

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S16GA	14	271	0
Part Specifications				
Spec No	Description	Target/Tolerance	Limits	Type
1	Wearshoe	3.227inches ± 0.010	3.237 3.217	
2	Wearshoe	2.432inches ± 0.010	2.442 2.422	
3	Wearshoe	2.500inches ± 0.010	2.510 2.490	
4	Wearshoe	6.000inches ± 0.010	6.010 5.990	
5	Wearshoe	12.104inches ± 0.010	12.114 12.094	
6	Wearshoe	18.000inches ± 0.010	18.010 17.990	
7	Wearshoe	18.000inches ± 0.030	18.030 17.970	
8	Wearshoe	9.000inches ± 0.030	9.030 8.970	
9	Wearshoe	11.500inches ± 0.030	11.530 11.470	
10	Wearshoe	0.300inches ± 0.010	0.310 0.290	
11	Wearshoe	0.300inches ± 0.010	0.310 0.290	
12	Wearshoe	0.188inches + 0.005 - 0.001	0.193 0.187	
13	Wearshoe	0.375inches ± 0.010	0.385 0.365	
14	Wearshoe	0.063inches ± 0.010	0.073 0.053	

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



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